



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G00332-3G-PO

Job Sheet 191874



Part No: RBW6405G00332-3G-PO **Job Qty:** 1 pcs

Part Name: Tail Rotor Pitch Control Adjustment Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: ~~5/7/19~~ 6/10/2019

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6405G00332-3G Rev.5 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	5/7/19	5/7/19	0.00	0.00	Purchasing - 1		DP JUN 07 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	1 pcs	5/7/19	5/7/19	0.00	0.00	Packaging 2 - 1 - B4B		DP JUN 07 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S188529



Part: RBW6405G00332-3G

Job No: 191874

Serial No/Batch: S188529

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 06/07/19

Plex 3/11/19 2:30 PM dart.Lussier.Patrick

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 6	1 pcs	5/7/19	0.00 0.00	QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
121	Small Fab - 2 - B4B	1 pcs	5/7/19	0.00 0.00	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
122	QC 5	1 pcs	5/7/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
130	Packaging 3-1 - Stock - B4B	1 pcs	5/7/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Plex 3/11/19 2:30 PM dart.Lussier.Patrick

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					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

GA097

140 QC 21 - FG

1 pcs

5/7/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - SA - 53

JUN 11 2019

Part Op 100 - (Purchasing) Issue P/O: 043647 MANUFACTURE RBW6405G00332-3G AS PER DWG Supplier: METEC
 Descriptions: Certificate of conformity is required

110 - (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

121 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 as per
 DWG sheet 5. 3-Install placard using drive screws.

122 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

x1 p hys

March 11, 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G00332-3GP	Tail Rotor Pitch Control Adjustment Tool	1 pcs (1 ea)	100-Purchasing	5188528
90081A077	Drive Screw #2 1/4" Long	4 Ea (4 ea)	121-Small Fab - 2 - B4B	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	121-Small Fab - 2 - B4B	5021040

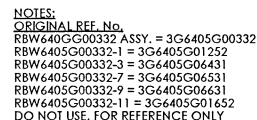
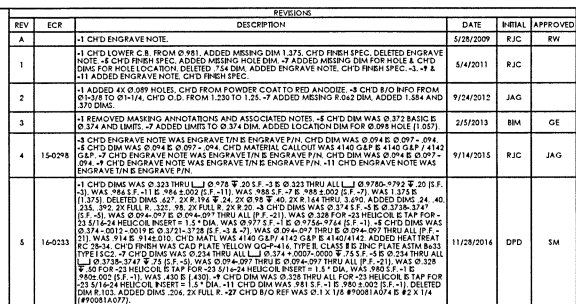
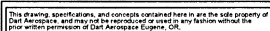
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6405G00332-3GP	1	0	0
121-Small Fab - 2 - B4B	90081A077	4	106	0
	RB41011	1	388	0

Part Specifications

Specifications could not be found.

Plex 3/11/19 2:30 PM dart.Lussier.Patrick



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	BASE	4061		2
			-3	1	ROUND SEAT	4061		2
			-5	2	STUD	4140/4142		5
			-7	1	STUDE SEAT	4061		4
			-9	2	KNOB	4061		7
			-11	1	PORTER	4061		6
B/O	-12			1	ROUND NUT	S.S.	#10-32 UNF (ESENTHRA 45EM-5)	1
B/O	-15	2		2	HEXHEAD CAP SCREW	STEEL	#1/4-24 UNF (SPENCER AIRCRAFT RANS-5A)	1
B/O	-17	2		2	FLAT WASHER	STEEL	05/16 (SPENCER AIRCRAFT RANR40-314)	1
B/O	-19	1		1	HEX HEAD CAP SCREW	STEEL	#10-32 UNF 7/8 (SPENCER AIRCRAFT RAN13-7A)	1
B/O	-21	1		1	ROLL PIN	S.S.	03/32 X 1 (MCMASTER-CARR #222/24149)	1
B/O	-23	4		4	HELICOIL	ALUM.	#1/4-24 UNF X 1/2 (MCMASTER-CARR #91735A233)	1
B/O	-27	4		4	4-20 COARSE SCREW	COATED STEEL	#2-1/4 X 1/2 (MCMASTER-CARR #9081A007)	1
B/O					PARAFITAGARD	ALUMINUM	994101	1

DO NOT USE FOR REFERENCE ONLY			
			
TITLE T/R PITCH CONTROL LINK ADJUSTING TOOL			
DWG NO. RBW6405G00332-3G			REV 5
MATERIAL PERRITT SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX = .000 FRACTIONS & 1/8 .XX = .01 ANGLES 5° .X = .005 SURFACES ±1/4"	
DRAWN BY: PERRITT		1. BREAK ALL SHARP EDGES	
CHECKED: CLOUGH		2. HONED TO .0015"	
USER APPR: ANDERSON		3. AFTER PLATING, LIMITS APPLY	
LINA APPR:		4. AFTER PLATING, LIMITS AND TOLER. PER ASTM VILK-2000	
APPROVED: MACKOWSKI		USE FORM NO.	
SCALE 1:1		SHEET 1	
DATE	1/13/2008	AGUSTA T OF 7	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER PO042847



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042847

PO Date: 3/11/19

Due Date: ~~5/7/19~~ 5/21/2019

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lussier, Patrick Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191873	RBW6205G11532-3GP			Swashplate Support Stand As Per Dwg RBW6205G11532-3G REV 5	Firmed	-	5/7/19 21	2 pcs	0 pcs	2 pcs	\$8,106.00/pcs	\$16,212.00
2	191874	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed	-	5/7/19 21	1 pcs	0 pcs	1 pcs	\$1,500.00/pcs	\$1,500.00
3	191875	RBW6405G02131-3GP			Tail Rotor Blade Damper Attachment Bushing Removal REV D	Firmed	-	5/7/19 21	2 pcs	0 pcs	2 pcs	\$500.00/pcs	\$1,000.00
4	191876	RBW6305G26631-3G-1P			Pin REV 2	Firmed	-	5/7/19 5/30/2019	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
5	191877	RBW6305G26631-3G-3P			Handle rev 2	Firmed	-	5/7/19 5/30/2019	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
												Grand Total:	\$19,612.00



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER PO042847



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 3/12/19 9:41 AM dart.Lussier.Patrick



METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25386
Shipment Date: 06-Jun-2019
Ship Via: Pick up at METEC
Order Number: 3606
Order Date: 03/13/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO042847
Terms: Net 60 Days

Quantity						Description	Revision	Job Number
Item	Open	Shipped	B/O	Canceled	Unit			
2	1	1	0	0	EA	RBW6405G00332-3GP Tail Rotor Pitch Control Adjustment Tool	5	3606-02

DAS
61
9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1	RBW6405G00332-3GP	Tail Rotor Pitch Control Adjustment Tool	5	42847
	DAS 61 9-88			

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, June 6, 2019